



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3574-2

Job Sheet 178741



Part No: D3574-2

Job Qty: 1 ea

Part Name: Cabin Floor Protector



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/7/18

Job Tracking No:

Due Date: 6/22/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev :A New Issue 07-01-22 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		6/22/18	0.00	0.00	Start Up Waterjet		SC 18/06/18
100	Waterjet	1 pcs		6/22/18	0.72	0.43	Waterjet1		SC 18/06/18
110	QC	1 pcs		6/22/18	0.00	0.00	QC2 Waterjet-2		SC 18/06/18
120	QC	1 pcs		6/22/18	0.00	0.00	QC8-3		18-06-11
150	Packaging	1 pcs		6/22/18	0.00	0.00	Packaging3		11/10
160	QC21-SA	1 Ea		6/22/18	0.00	0.00	QC21		JUN 11 2018

Part Op Descriptions: 100 - 1-Cut as per Dwg D3574 Dwg Rev: B Prog Rev: B 2-Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MLEXS.125-F60029-04	GE Plastics Lexan Sheet (Dark Grey)	21.5500 sf (21.55 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MLEXS.125-F60029-04	22	3,276	0

Part Specifications

Specifications could not be found.

Plex 6/7/18 9:52 AM dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																			
Date : _____	Step #: _____	LOTV Effective : _____		MRB (QSI042) Approval																																																																																																	
Description Work Order L 		 Part: D3574-2 Job No: 178741 Serial No/Batch: S079504 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 06/10/18		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																																																																	
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DART AEROSPACE LTD		Work Order: 178741
Description: Cabin Floor Protector		Part Number: D3574-2
Inspection Dwg: D3574	Rev: B	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	Ø3.00	1		VSC-01	
7.37	+/-0.030	7.37	1		TAP	
10.75	+/-0.030	10.75	1			
11.00	+/-0.030	11.00	1			
15.25	+/-0.030	15.25	1			
25.87	+/-0.030	25.87	1			
39.75	+/-0.030	39.75	1			
44.75	+/-0.030	44.75	1			
53.51	+/-0.030	53.51	1			
63.50	+/-0.030	63.50	1			
65.25	+/-0.030	65.25	1			
10.75	+/-0.030	10.75	1			
11.00	+/-0.030	11.00	1			
14.75	+/-0.030	14.75	1			
25.50	+/-0.030	25.50	1			
25.75	+/-0.030	25.75	1			
26.00	+/-0.030	26.00	1			
32.87	+/-0.030	32.87	1			
38.81	+/-0.030	38.81	1			
45.00	+/-0.030	45.00	1			
48.25	+/-0.030	48.25	1			
58.38	+/-0.030	58.38	1			
61.25	+/-0.030	61.25	1			
64.13	+/-0.030	64.13	1			
64.63	+/-0.030	64.63	1			
66.50	+/-0.030	66.50	1			
7.50	+/-0.030	7.50	1			
9.50	+/-0.030	9.50	1			
10.38	+/-0.030	10.38	1			
10.88	+/-0.030	10.88	1			
14.50	+/-0.030	14.50	1			
16.56	+/-0.030	16.56	1			
18.75	+/-0.030	18.75	1			
24.13	+/-0.030	24.13	1			

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
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DART AEROSPACE LTD		Work Order: 178 741
Description: Cabin Floor Protector		Part Number: D3574-2
Inspection Dwg: D3574	Rev: B	Page 2 of 2

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26.50	+/-0.030	26.50	1			
30.50	+/-0.030	30.50	1			
33.88	+/-0.030	33.88	1			
39.50	+/-0.030	39.50	1			
40.25	+/-0.030	40.25	1			
43.50	+/-0.030	43.50	1			
46.60	+/-0.030	46.60	1			
7.63	+/-0.030	7.63	1			
11.00	+/-0.030	11.00	1			
11.50	+/-0.030	11.50	1			
16.75	+/-0.030	16.75	1			
19.00	+/-0.030	19.00	1			
22.50	+/-0.030	22.50	1			
30.75	+/-0.030	30.75	1			
32.63	+/-0.030	32.63	1			
32.75	+/-0.030	32.75	1			
35.13	+/-0.030	35.13	1			
36.50	+/-0.030	36.50	1			
40.00	+/-0.030	40.00	1			
41.88	+/-0.030	41.88	1			
43.63	+/-0.030	43.63	1			
0.125	+/-0.010	0.125	1			

Measured by: SC	Audited by:	Prototype Approval:	N/A
Date: 18/06/10	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	

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